Quality Control

| Work Order November-08-11 | | 53 | | *76 | 253* | | | | | | | Page 1 |
|---|----------------------|---|--|--|----------------|------------------------|--------------|---------------|---------------|---------------|------------------|----------------|
| Revision ID: Item Name: Co Start Date: 08 Required Date: 28 | 8/11/2011 \$ | ation, High Àft Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | Accept | | NNN4(Item ID: omer: |)10(| ገ* | Setup | Start Stop | ı Vı | S1* S2* |
| | Process Plan: QC: | M.C.J | Date: | © 8 Tooling: SPC (Y/N): | | Date: | | | Run | Start Stop | *NI *NI | R1* R2* |
| Sequence ID/ Work Center ID | | Operation Description | The state of the s | Set Up/ Run Hours | -Too | l ID Tool# | Plan Code | Accept Qty | t Reje Qty | | Reject Number | Insp. Stamp |
| Draw Nbr | Revisi | on Nbr | | | w e v | | | | | | | |
| D350-748-241 | F | | | | | | | | | | | |
| *1 \\ \\ DC\\\ \text{DC ocument Control} | · D | OOCUMENT CONTR Memo Photocopy | OL bluefile & type labels per | 0.00 0.00 r PPPD350-748-201 | GlaGB02 | | > | 3 | | · | | · |
| *110 *110* CNC Bend 2 CNC Alpha 160 Bender | | BENDING MACHINE Memo Bend tube Folio FT_ | | 0.00 0.00 11 using CNC bender prog | gram D350A and | N | | 12 | | | 19 | P7 |
| 120 * 1 2 0 * QC | Q | OC15 Crosstube Dime | ensional Check | 0.00 | | | | | | | | |

| Dart | Aeros | pace | Ltd |
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| W/O: | | 76Z53 WORK ORDER CHANGES | | | | | | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | | | |
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Part No: DSD-748-201 PAR #: ____ Fault Category: Landing Georgical NCR: Yes No DQA: April Date: 12/03/16

Resolution: SCAD Disposition: SCAD QA: N/C Closed: _____ Date: 12/03/16

| NCR: | (2X 6 | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | |
|---------|------------------|--|-------------------|---|---------------|---------------------------|-----------------------|--------------------------|--|--|--|
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Corrective Action Section B Action Description Chief Eng | Sign & | Verification Section C | Approval Chief Eng | Approval QC Inspector | | | |
| 12-1-19 | 110 | Tube Kinhajwhile Banding en 11517 of two Q 20"26" From ruly. | 12/01/2° | Scaop or Destry | MO 12/1/25 | 12-1-25 | 12/01/25 | alou/5 | | | |
| | 7 | \ - \ - | | | | | | | | | |
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| Work Ord November-08-1 | | | | *762 | 253* | | | | | | Page | 2 |
|--|-----------------------------|------------------------------------|---------------------------|-----------------------|--------------------------|--------------|--------------|---------------|---------------|------------------|----------------|---|
| Item ID: Revision ID: Item Name: | D350-748-2 Crosstube Ins | 01 tallation, High Aft | | Accept | *N900 | 040 | 100 |)* | Setup Star | 1 7 | S1* S2* | |
| Start Date: Required Date | 08/11/2011 :: 28/11/2011 | Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | | Cust Item I Customer: | D: | | | | | | |
| Reference: | | | | | | | | | Run Sta | rt *N | □ 4* | |
| Approvals: | Process Pla | an: | Date: | Tooling: _ SPC (Y/N): | | ate: ate: | | | Sto | р | R2* | |
| Sequence ID/ Work Center I | I D | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp | |
| *125* HandFXtube Hand Finishing Cr | osstuhes | Memo ***Stress re | lief*** | 0.00 | | | | | | | | _ |
| Traine I mishing On | 05314043 | Heat treat cr Temp: | osstube as per QSI010 4.3 | | | | | | | | | |

127

127

QC5- Inspect part completeness to step on $\ensuremath{W/O}$

0.00

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Quality Control

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| W/O: | WORK ORDER CHANGES | | | | | | | | | |
|-------------|--------------------|-------------------|----------------------|------------------------------|----------------|--------------|-------------------------------------|--------------------------|--|--|
| DATE | STEP | PRO | OCEDURE CHA | NGE | Ву | Date Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
| · | | | | | | | Prod Wgr | · | | |
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| Part No | • | PAR #: | Fault Cate | gory: | NCR: Yes | No DQA: | Date: _ | | | |
| Resolution: | | | Disposition | n: | _ QA: N/C Clo | sed: | Date: _ | | | |
| NCR: | | | WORK ORDI | ER NON-CONFORMA | NCE (NCR) | | | | | |
| DATE | OTED | Description of NC | | Corrective Action Section | | Verification | Approval | Approval | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | QC Inspector | | |
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| Work Ord November-08-1 | | | | *762 | 5.3* | | | | | | Page 3 |
|---|--------------------------|------------------------------------|---|-------------------------------------|--------------------------|--------|--------------|---------------|---------------|------------------|----------------|
| Item ID: Revision ID: | D350-748-2 | 01 | | Accept | *N900 | 040 | 100 |)* § | Setup Start | 1 71 | S1* |
| Item Name: | Crosstube Ins | stallation, High Aft | | | | | | | Stop | *N | S2* |
| Start Date: Required Date: Reference: | 08/11/2011 28/11/2011 | Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | | Cust Item I Customer: | D: | | | 0. | | |
| Approvals: | Process Pla | an: | Date: | Tooling: | D: | ate: | - | F | Run Star | 171 | R1* |
| | QC: | | Date: | SPC (Y/N): | D: | ate: | | | Stop | *N | R2* |
| Sequence ID/ Work Center II |) | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| 130 | | | | 0.00 | | | | | | | |
| *130* | | Crosstubes | | | | | | | | | |
| Crosstubes | | Memo | | 0.00 | | | | | | | |
| Crosstubes | | | as per Dwg D350-74 Il table as per QSI 010 | 8-241 Using DT8876 Drill Jigs,) | | | | | | | |
| | | 2-Deburr | | | | | | | | | |
| | | 3-Engrave Pa | art # and Batch # as p | er Dwg D350-748-241 | | | | | | | |
| | | 4-Remove al | l marks from tube wi | thin limits of D350-748-241 | | | | | | | |
| | | 5- Apply a li | ght coat of LPS3 on t Batch: | he interior of tube | | | | | | | |

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Quality Control

QC6-Inspect dimensions to drawing

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| W/O: | | WORK ORDER CHANGES | | | | | | | | | | | | |
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| DATE | STEP | PRO | OCEDURE CHAI | NGE | | Ву | Date | Qty | Approval Chief Eng / | Approval QC Inspector | | | | |
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| Part No | • | PAR #: | Fault Cate | NCF | NCR: Yes No DQA: Date: | | | | | | | | | |
| Resolution: | | | | | | | | | | | | | | |
| NCR: | | | WORK ORDE | ER NON-CONFORM | IANCE | (NCR |) | | | | | | | |
| DATE | STEP | Description of NC | | ction B | | Verific | ation | Approval | Approval | | | | | |
| DATE | SIEP | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | Secti | on C | Chief Eng | QC Inspector | | | | |
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| | Work Order ID 76253 November-08-11 7:48:04 AM | | | *76253* | | | | | | | Page 4 | | |
|--------------------------------|--|--|--|---|-------------|------------|--------------|---------------|---------------|------------------|----------------|--|--|
| Item ID: Revision ID: | D350-748-2 | 01 | , | Accept | *N900 | <u>040</u> | 100 |) * | Setup Sta | rt *N | S1* | | |
| | Crosstube Ins | tallation, High Aft | | | | | | | Sto | *N | S2* | | |
| Start Date: | 08/11/2011 | Start Qty: 1.00 | *1* | | Cust Item 1 | D: | | | | | | | |
| Required Date: | 28/11/2011 | Req'd Qty: 1.00 | *1* | | Customer: | | | | | | | | |
| Reference: | | | | | | | _ | 1 | Run Sta | rt J.B. | — 4 sh | | |
| Approvals: | Process Pla | an: | Date: | Tooling: | D: | ate: | | | | 1/1 | R1* | | |
| | QC: | - | Date: | SPC (Y/N): | D | ate: | | | Sto | *N | R2* | | |
| Sequence ID/ Work Center II |) | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp | | |
| 150 | | Outsource process-Cadp | late per QSI017 4.1.9.1 | 0.00 | | | | | | | | | |
| *150* Outsource3 | | Memo | | 0.00 | | | | - | | | | | |
| Outsource process - | Cad plate | Magnetic Pa Cadium Pla Embrittle re Possibe Sup | at 375° for 5 hours article Inspect per ASTM te per AMS-QQ-P-416B, the lief at 375° for 8 hours, Cliplier: Southwest United Ir ifficate of Conformity is at | Class 1, Type 2 hromate Treat ndustries | | | | | | | | | |
| 160 | | Receive & Inspect for Da | amage & Mat'l Certs | 0.00 | | | | | | | | | |
| *160* Packaging | | Memo | | 0.00 | | | | | | | | | |
| Packaging | | Ensure certi | ficate of conformity is atta | ached | | | | | | | | | |
| 170 | | QC5- Inspect part compl | eteness to step on W/O | 0.00 | | | | | | | | | |
| *170* QC | | Memo | | 0.00 | | | | | - | | | | |

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Quality Control

| W/O: | | , 3,31 | WC | ES | | * F - T | | |
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| DATE | STEP | PR | OCEDURE CHAI | NGE | Ву | Date Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cate | gory: | NCR: Yes | No DQA: | Date: _ | |
| | | esolution: | | | | | | |
| NCR: | | | WORK ORDE | ER NON-CONFORMA | NCE (NCR) |) | | |
| DATE | STEP | Description of NC | | Corrective Action Section | | Verification | Approval | Approval |
| DATE | SIEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | QC Inspector |
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| Work Orde November-08-11 | | | | *762 | 253* | | | | | | Page 5 |
|---|--------------------------|------------------------------------|------------------------------------|----------------------|--------------------------|------------|--------------|-------------------------------------|-----------------|------------------|----------------|
| Revision ID: | D350-748-20 | 01 tallation, High Aft | | Accept | *N900 | 040 | 100 |)* | Setup Sta | 1 71 | S1* S2* |
| Start Date: Required Date: Reference: | 08/11/2011 28/11/2011 | Start Qty: 1.00 Req'd Qty: 1.00 | *1 ³ *1 ³ | | Cust Item I Customer: | D: | | | | | |
| Approvals: | Process Pla | ın: | Date: | Tooling: | Da | ate: | _ | | Run Sta | 171 | R1* |
| | QC: | | Date: | SPC (Y/N): | Da | ate: | | | Sto | ^{op} *N | R2* |
| Sequence ID/ Work Center II |) | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | t Reject Qty | Reject Number | Insp. Stamp |
| *180* SprayPaint Spray Painting | | SprayPaint Memo | de crosstube as per Ç | 0.00 | | | | · · · · · · · · · · · · · · · · · · | | <u></u> · | <u> </u> |
| opray ramung | | | side of Tube as per D | | | | | | | | |
| ¹⁹⁰ *19∩* | | QC14- Inspect Spray Pa | nt | 0.00 | | | | | | | |
| QC | | Memo | | 0.00 | | | | | | | |

200

Crosstubes

200 Crosstubes

Quality Control

0.00 Memo

Then, Wrap in plastic bag to protect from scratches

Crosstubes

1-Install Ground wire Insert,then insert screw and washer
2-Install Abraision strips as per Dwg D350-748-241 & QSI 035.
3-Install supports Using Dt8876 as per Dwg D350-748-241,Torque to 60-80 IN-

0.00

LBS

| W/O: | | | W | ORK ORDER CHANG | ES | | | | | |
|-------------------|------|-------------------|---------------------------------------|--|----------|---------------|---------|------------|-------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CH | ANGE | В | у | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cat | egory: | _ NCR: ` | Yes N | o DQA | \ : | Date: | |
| | Re | esolution: | Dispositi | on: | _ QA: N/ | C Clos | sed: | | Date: | |
| NCR: | | | WORK ORE | DER NON-CONFORM | ANCE (I | NCR) | | | | |
| DATE | 0750 | Description of NC | | | ion B | | Verific | ation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | | ign & Date | Section | | Chief Eng | QC Inspector |
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| Work Order ID 76253 November-08-11 7:48:04 AM | | *76253* | | | | | | Page 6 | | | | |
|--|--------------------------|------------------------------------|------------------------|----------------------|------------------------|------------|--------------|---------------|------------|---------------|------------------|----------------|
| Item ID: Revision ID: | D350-748-20 |)1 | | Accept | *N900 | 040 | 100 |)* | Setup | Start | 14. | S1* |
| Item Name: | Crosstube Inst | allation, High Aft | | | | | | | | Stop | *N: | S2* |
| Required Date: | 08/11/2011 28/11/2011 | Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | | Cust Item II Customer: | D: | | | | | | |
| Reference: Approvals: | Process Pla | n: | Date: | Tooling: | Da | ıte: | | 1 | Run | Start Stop | *NI | ₹1* |
| | QC: | | Date: | _ SPC (Y/N): | Da | ite: | | | | Stop | *NI | ₹2* |
| Sequence ID/ Work Center ID |) | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Rej Qty | | Reject Number | Insp. Stamp |
| 210 | | QC5- Inspect part comple | eteness to step on W/O | 0.00 | | | | | | | | |
| *210* QC Quality Control | | Memo | | 0.00 | | | | | | | | |
| 220 | | Pick Kit | | 0.00 | | | | | | | | |
| *220* Packaging Packaging | | Мето | | 0.00 | | | | | - | | . | |
| 230 | | QC4- 100% Inspect kits | for completeness | 0.00 | | | | | | | | |

0.00

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Quality Control

| W/O: | | | W | ORK ORDER CHANG | ES | | | |
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| DATE | STEP | PRO | OCEDURE CHA | ANGE | Ву | Date Q | ty Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | | PAR #: | Fault Cate | egory: | _ NCR: Yes I | No DQA: _ | Date: _ | |
| | R | esolution: | Disposition | on: | _ QA: N/C Clo | sed: | Date: _ | |
| NCR: | | | WORK ORD | ER NON-CONFORMA | ANCE (NCR |) | | |
| DATE | CTED | Description of NC | | Corrective Action Section | | Verification | n Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | | QC Inspector |
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| Work Orde | | | | *762 | 253* | | | | | | Page 7 |
|---|--------------------------|------------------------------------|----------------------------|---|--------------------------|------------|--------------|---------------|-----------------|--------------------|----------------|
| Revision ID: | D350-748-20 | 01 tallation, High Aft | | Accept | *N900 | 040 | 100 |)* s | Setup Star | I VI | S1* S2* |
| Start Date: Required Date: Reference: | 08/11/2011 28/11/2011 | Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | | Cust Item I Customer: | D: | | | | | |
| Approvals: | | ın: | | Tooling: SPC (Y/N): | | ate: | | F | tun Star Sto | 1/1 | R1* R2* |
| Sequence ID/ Work Center II 240 *740* Packaging Packaging |) | Location: | l pack for shipping as per | Set Up/ Run Hours 0.00 0.00 PPPD350-748-201 | Tool ID | Tool# | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| 250 *250* QC | | QC21- Final Inspection | | 0.00 | | | | | ••••• | - · - - | |

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Quality Control

| W/O: | | | W | ORK ORDER CHANG | ES | | | | |
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| DATE | STEP | PRO | OCEDURE CHA | ANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cate | egory: | _ NCR: Yes | No DQ | A: | Date: _ | |
| | Re | esolution: | Disposition | on: | _ QA: N/C C | osed: | | Date: _ | |
| NCR: | | | WORK ORD | ER NON-CONFORMA | NCE (NCF | ₹) | | | |
| DATE | OTED | Description of NC | | Corrective Action Secti | | Verific | cation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign 8 Date | | ion C | Chief Eng | QC Inspector |
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Page 1

Work Order ID: 76253

76253

Parent Item:

D350-748-201

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 08/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A New Issue 06-07-05 JLM

IPP Rev: B Update qty of MS21042L5 06-09-12 KJ

Purchased

NAS1149D0363J Purchased

IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD

IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC

IPP Rev: E 08.12.11 Step17 was step 21 KJ Verified by:EC IPP Rev:F

No

No

10.08.04 added QSI010 4.3 DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D350-748-241TRN | | Manufactured | No | | | 110 | Each | 3.0000 | 1 | 1 | | | |
| *D350-748 | R-241TF | 8N* | | | | | | | ** | | M | 12- | 1-19 |

Crosstube Turning Detail

| Location | Loc | Qty | Loc Code | | |
|-----------|-----|------|-----------|---------|---------|
| LG >33337 | | 2 | | | |
| 61314 | | 0 | | <u></u> | <u></u> |
| 61315 | | 0 | | | |
| 70654 | | 1 | | | |
| 72332 | | 1 | | | |
| LG003 | | 1 | | | |
| 68840 | | 1 | | | |
| | 200 | Each | 2,418.000 | 1 | 1 |
| | | | * | * | |

ALS4-1032-225

Insert

ALS4-1032-225

| Location | Loc | c Oty | Loc Code | | |
|----------|-----|-------|----------|------------|---|
| ST281 | | 2418 | | | |
| 108696 | | 498 | | | |
| 110768 | | 62 | | | |
| 118386 | | 858 | | | |
| 118966 | | 1000 | | | |
| | 200 | Each | 0.0000 | 1 | 1 |
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| W/O: | | | W | ORK ORDER CHANG | ES | | | |
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| DATE | STEP | PRO | OCEDURE CHA | ANGE | Ву | Date Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | egory: | _ NCR: Yes l | No DQA: | Date: _ | |
| | Re | esolution: | Dispositio | on: | _ QA: N/C Cld | sed: | Date: _ | |
| NCR: | | 1 | WORK ORD | ER NON-CONFORMA | ANCE (NCR |) | | |
| DATE | | Description of NC | | Corrective Action Section | | Verification | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | QC Inspector |
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| Picklist Prin | 1 |
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| November-08-11 | |

Page 2

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Work Order ID: 76253

76253

Parent Item:

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

D350-748-201

Start Date: 08/11/2011

**

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2856-400

Manufactured

No

No

200

f

304.0945

1.181

1.243158

D2856-400

Abraison Strip

Location ST403 ST409

68076 63735 71164 73491

0.3149 303.7796 0.6696 87.11 216

Loc Qty

0.3149

Loc Code

1- cut as per dwg D2856

D3502-1

Manufactured No

Purchased

200

Each

37.0000

Loc Code

2

**

2

D3502-1

MS21920-20

Location Loc Qty ST063 37 3 68951 72129 14 73419 20 200 Each

1 1

72.0000

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2

Loc Code

Clamp (per MIL-DTL-8783C)

Loc Qty Location LG050 72 116799 10 118649 12 119386 50

2

November-08-11 7:48:09 AM

Shop Packet Print

Page 2

| W/O: | | | WC | RK ORDER CHANGE | S | | | | |
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| DATE | STEP | PRO | OCEDURE CHAI | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cate | jory: | NCR: Yes | No DQA | \ : | Date: _ | |
| | R | esolution: | Disposition | n: | QA: N/C CI | osed: | | Date: | |
| NCR: | | | WORK ORDE | R NON-CONFORMA | NCE (NCR |) | | | |
| DATE | | Description of NC | | Corrective Action Section | n B | | | | |
| | I ATER I | Description of NC | | | | Verific | ation | Annroval | Annroval |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verific Section | ation on C | Approval Chief Eng | Approval QC Inspector |
| UAIE | STEP | Section A | | | | Section Section | ation on C | Approval Chief Eng | |
| DATE | STEP | Section A | | | | Section Section | ation on C | Approval Chief Eng | |
| DATE | STEP | Section A | | | | Section | ation on C | Approval Chief Eng | |
| DATE | STEP | Section A | | | | Section Section | ation on C | Approval Chief Eng | |
| DATE | STEP | Section A | | | | Section | ation on C | Approval Chief Eng | |
| DATE | STEP | Section A | | | | Section | ation on C | Approval Chief Eng | |
| DATE | STEP | Section A | | | | Section | ation on C | Approval Chief Eng | |
| DATE | STEP | Section A | | | | Section | ation on C | Approval Chief Eng | |
| DATE | STEP | Section A | | | | Section | ation on C | Approval Chief Eng | |
| DATE | STEP | Section A | | | | Verific Section | ation on C | Approval Chief Eng | |

| Work Order ID: 76253 | 1 27- | *7 | 6253* | | | | | | |
|--|---------------|------|------------------|---------------|----------|-----------|-------------|-------------|---------------------------|
| Parent Item: D350-748-201 | | | | 204* | | | | | |
| Parent Item Name: Crosstube Installati | ion. High Aft | "1 1 | 350-748-2 | / ()1" | | Ste | art Date: 0 | R/11/2011 | Required Date: 28/11/2011 |
| Turent remarkance | , | | | | | | art Qty: 1. | | Required Qty: 1.00 |
| MC27020 1 10 | D 1 1 | NI- | | 200 | F1 | | | | Required Qty. 1.00 |
| MS27039-1-10 | Purchased | No | | 200 | Each | 304.0000 | 1 | 1 | |
| *MS27039-1-10* | | | | | | | ** | | |
| | | | Location | <u>I</u> | oc Qty | Loc Code | | | |
| | | | ST291 | | 304 | | | | _ |
| | | | 118612 | | 154 | | | | |
| | | | 119307 | | 100 | | | | <u> </u> |
| | | | 119531 | | 50 | | | | _ |
| AN4-41A | Purchased | No | | 220 | Each | 305.0000 | 8 | 8 | |
| *AN4-41A* | | | | | | | ** | | |
| | | | Location | <u>1</u> | oc Qty | Loc Code | | | |
| | | | ST360 | | 305 | | | w | |
| | | | 115108 | | 3 | | | | _ |
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| AN4-6A | Purchased | No | | 220 | Each | 5,476.000 | 16 | 16 | |
| *AN4-6A* | | | | | | | ** | | |
| | | | Location | <u>I</u> | oc Qty | Loc Code | | | |
| | | | ST356 | | 476 | | | | ·- |
| | | | 118838 | | 276 | | | | · _ |
| | | | 119127 | | 200 | | | | _ |
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| DATE | STEP | PRO | OCEDURE CHAN | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cateç | gory: | _ NCR: Yes | No DQ | A: | Date: | |
| | Res | solution: | Disposition | 1: | _ QA: N/C CI | osed: | | Date: | |
| NCR: | | , | WORK ORDE | ER NON-CONFORMA | ANCE (NCF | R) | | | |
| DATE | STEP | Description of NC | Initial | Corrective Action Section Description | ion B | Verific | | Approval | Approval |
| | | Section A | Chief Eng | Chief Eng | Date | Secti | on C | Chief Eng | QC Inspector |
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| Picklist Print November-08-11 7 | | | | | | | | | | | Pag |
|--|------------------------|--------------|-------------|----------------|------------|---------------|----------|----------|--------------|-----------|--------------------------|
| Work Order ID: 7 | 6253 | | *7(| 6253 | } * | | | | | | |
| Parent Item: D | 350-748-201 | | | | -748-2 |) () () | | | | | |
| Parent Item Name: | Crosstube Installation | on, High Aft | 1) | เภอบะ | -/40-/ | () 1 | | St | art Date: 08 | 8/11/2011 | Required Date: 28/11/201 |
| | | , 5 | | | | | | | tart Qty: 1. | | Required Qty: 1.00 |
| AN5-32A | | Purchased | No | | | 220 | Each | 195.0000 | 4 | 4 | roquirou Quy mos |
| *AN5-32 | Α* | | | | | | | | ** | | |
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| | | | | ST339 | | | 195 | | | | _ |
| | | | | | 118422 | | 20 | | | | _ |
| | | | | | 118628 | | 50 | | | | |
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| NOCOLDANG | NIA CLI 140 DO 14 CO I | | X 1. | | 119328 | 220 | 100 | 0.0000 | 22 | | |
| N960JD416 | NAS1149D0463J | Purchased | No | | | 220 | Each | 0.0000 | 32 | 32 | |
| ^k AN960.1 Vasher | ID416* | | | | | | | | ** | | |
| N960JD516 | NAS1149D0563J | Purchased | No | | | 220 | Each | 0.0000 | 8 | 8 | |
| *AN960.1 | ID516* | | | | | | | | ** | | |
| 3500-1 | | Manufactured | No | | | 220 | Each | 16.0000 | 4 | 4 | |
| *D3500- | 1* | | | | | | | | ** | | |
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| 03501-1 | | Manufactured | No | | | 220 | Each | 237.0000 | 16 | 16 | |
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| W/O: | | | WC | ORK ORDER CHANGE | ES | | | | |
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| DATE | STEP | PRO | OCEDURE CHA | | Ву | Date | Qty | Approval Chief Eng / | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cate | gory: | NCR: Yes | No DQ | A: | _ Date: _ | |
| | Re | esolution: | Disposition | າ: | QA: N/C Clo | osed: | | Date: | |
| NCR: | | | WORK ORDI | ER NON-CONFORMA | NCE (NCR |) | | | |
| D.4.T.E | 0750 | Description of NC | | Corrective Action Section | | Verific | cation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | ion C | Chief Eng | QC Inspector |
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|--|----------------------|---------------|------------|-----------------|-----------|-----------|-----------|-----------|---------------------------|
| Work Order ID: 76253 | | *7625 | ス* | | | | | | |
| Parent Item: D350-748-201 | | *D350 | | 201* | | | | | |
| Parent Item Name: Crosstube Instal | llation High Aft | 117.500 | J-/48-/ | / () " | | Stant | Data: 09 | 3/11/2011 | Required Date: 28/11/2011 |
| Tarent Item Name. | mation, riigii i iii | | | | | | t Qty: 1. | | Required Qty: 1.00 |
| N/C2104214 | 5 | N | | 220 | . | | - | | Required Qty. 1.00 |
| MS21042L4 | Purchased | No | | 220 | Each | 12,685.00 | 24 | 24 | |
| *MS21042I 4* | | | | | | * | * | | |
| | | Locati | <u>ion</u> | Lo | oc Qty | Loc Code | | | |
| | | ST300 | ı | | 1685 | | | | |
| | | | 117441 | | 51 | | | | |
| | | | 117601 | | 532 | | | | <u> </u> |
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| | | | 118927 | | 969 | | | | <u> </u> |
| | | ST516 | | | 6000 | | | | |
| | | | 119017 | | 6000 | | | | _ |
| | | ST518 | | | 5000 | | | | |
| | | | 119075 | | 5000 | | | | _ |
| MS21042L5 | Purchased | No | | 220 | Each | 2,358.000 | 4 | 4 | |
| *MS21042L5* | | | | | | * | * | | |
| 1144 | | <u>Locati</u> | <u>ion</u> | La | oc Qty | Loc Code | | | |
| | | ST300 | | | 858 | | | | |
| | | | 116105 | | 5 | | | | |
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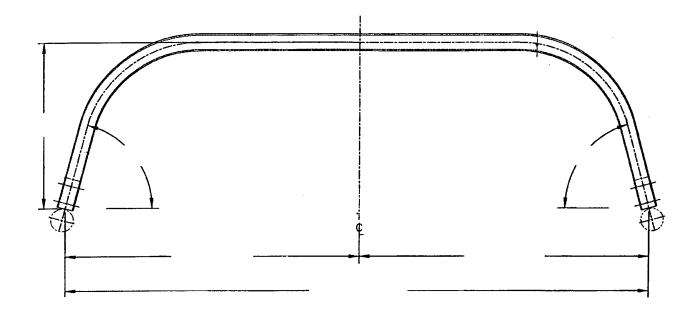
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| DATE | STEP | PRO | CEDURE CHAI | NGE | Ву | Date Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | gory: | _ NCR: Yes 1 | lo DQA: | Date: _ | |
| | Re | esolution: | Disposition | n: | _ QA: N/C Clo | sed: | Date: _ | _ |
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| | | Description of NC | | Corrective Action Section | | Verification | Approval | Approval |
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| DART AEROSPACE LTD | Work Order: | 76253 |
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| Description: Crosstube High Aft (AS350/355) | Part Number: | D350-748-201 |
| Inspection Dwg: D350-748-241 Rev: E | | Page 1 of 1 |

| Required Dimension | Min | Max |
|--------------------|-------|-------|
| Height | 31.22 | 31.48 |
| 1/2 Span | 40.77 | 41.03 |
| Angle | 75 | 77 |
| Total Span | 81.54 | 82.06 |



| | Con | nments | | | |
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| QC15 Inspection | |
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| Date | |

| Rev | Date | Change | Revised by | Approved |
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| Α | 07.02.06 | New Issue | KJ/JM | 1 |
| В | 10.08.23 | Dwg Rev updated | KJ | 11 |
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| W/O: | | | W | ORK ORDER CHAN | GES | • | | | | |
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| DATE | STEP | PRO | OCEDURE CH | ANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | · | PAR #: | Fault Cat | egory: | NCR: | Yes N | lo DQA: | | _ Date: _ | |
| | R | esolution: | Dispositi | on: | QA: 1 | VC Clo | sed: | | Date: | |
| NCR: | | | WORK ORE | DER NON-CONFORM | IANCE | (NCR) | | | | |
| DATE | STEP | Description of NC | | | ction B | <u> </u> | Verificat | ion | Ap proval | Approval |
| DAIL | J.E. | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | Section | С | Chief Eng | QC Inspector |
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Item Qty Part Number Description -241 D350-748-241 CROSSTUBE ASSEMBLY (AS 350/355 HI AFT) CROSSTUBE (OR D6018-125) D6015-125 2 D3502-1 SUPPORT 3 D2856-400-710 ABRASION STRIP 4 AELS-1032-225 INSERT WASHER (OR AN960JD10) NAS1149D0363J 6 CLAMP (PER DART SPEC. M-MS21920-20) MS21920-20 MS27039-1-10 SCREW 1

GENERAL NOTES:



1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6018-125

FINISHED LENGTH = 122,700±0.06

2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2 CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 29.85 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.



- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE. CENTERED OPPOSITE D3502-1 SUPPORT. PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES. NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.



15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

SHOP CEE'Y RETURN 201 ENGINEERICS UNCONTROL (T) COPS SUBJECT TO A APADATENT WITHOUT SEQUEL WORK ORIGINA M.C.J NO. 36253 11/11/08

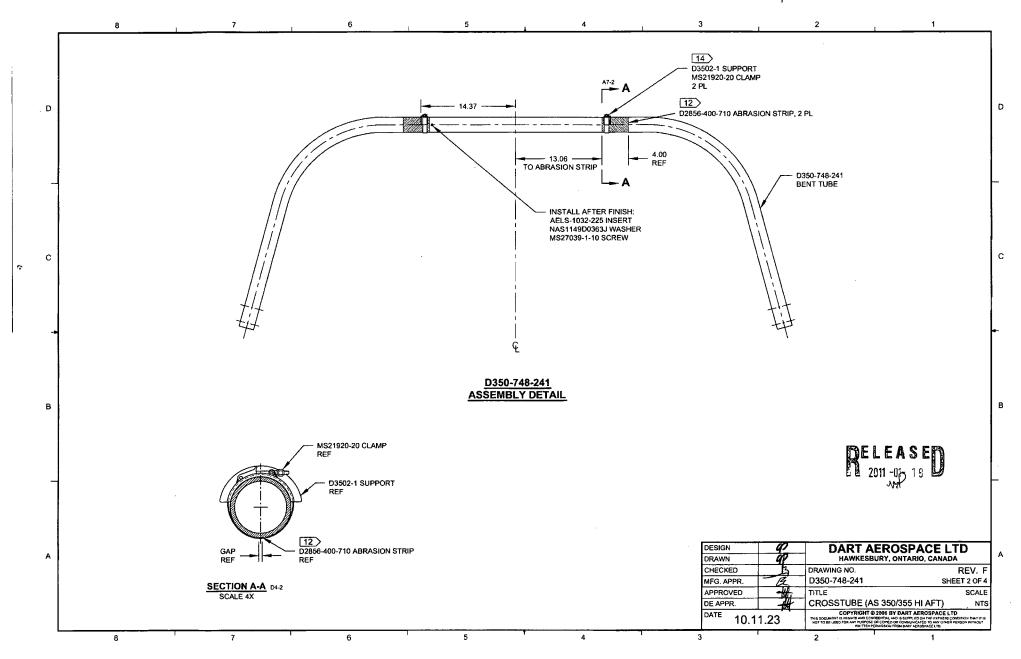


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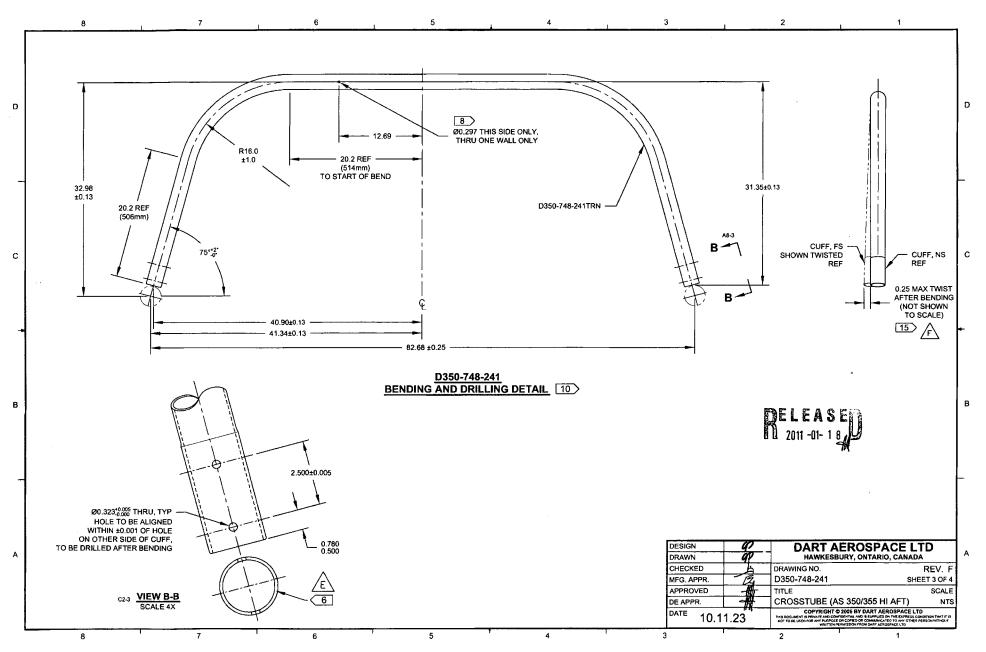
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| F | TWIST | LIMIT (A8-1, 0 | TION (B8-1) PER PAR 09-040, ADD C1-3), ADD D6015-125 OPTION NOW MACHINED (D1-4) | CP | 10.11.23 | | |
|---------------|--------|----------------|---|--------------|----------|--|--|
| E | STANE | ARDS; RELC | OTES; UPDATE TO CURRENT DCATED FLAG #6 PER PAR 08-046 ERANCES (ZN C6-3, D2-3) | RF | 09.09.30 | | |
| D | MAG. F | ARTICLE AN | D CAD PLATE AS MFD. | CP | 06.10.31 | | |
| С | ADD C | AD PLATING | | CP | 06.08.14 | | |
| В | ADD D | 6018-125 & PF | RIME AND PAINT | CP | 06.06.30 | | |
| Α | NEWIS | SSUE | | CP | 06.03.31 | | |
| REV. | | - | DESCRIPTION | BY | DATE | | |
| DESIGN P | | 92 | DART AEROSPACE LTI HAWKESBURY, ONTARIO, CANADA | | | | |
| CHECKE | D | <u> </u> | DRAWING NO. | | REV. F | | |
| MFG. APPR. | | Ey | D350-748-241 | SHEET 1 OF 4 | | | |
| APPROVED | | -14 | TITLE | | SCALE | | |
| DE APPR. | | All . | CROSSTUBE (AS 350/355 HI AFT) NT: | | | | |
| DATE 10.11.23 | | | COPYRIGHT © 2006 BY DART AEROSPACE LTD HIS DOQUMENT IS PRIMATE AND COMPERTURE AND THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPLETE OR SOME PROPERTY OF REPRISON WITHOUT | | | | |

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval Approvai** DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC Approval Approval** DATE STEP **Action Description** Sign & Initial Section A Section C Chief Eng QC Inspector Chief Eng Date Chief Eng

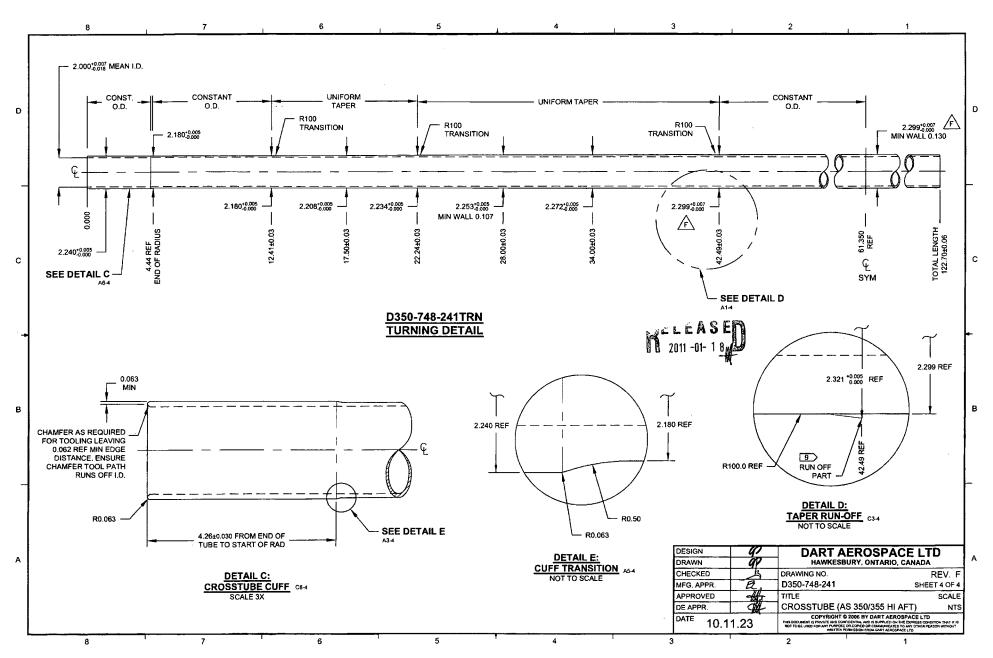


| W/O: | | | V | VORK ORDER CHANG | ES | | | |
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| DATE | STEP | PRO | CEDURE CH | IANGE | Ву | Date Qt | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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